

Work Order ID 71581

Page 1

Wednesday, July 06, 2011 1:24:54 PM

Item ID: D3535-23

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: C2 Date: 11/07/06 Tooling: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3535	Rev B

100 Waterjet FLOW WATER JET 0.00

Waterjet
FLOW CNC Waterjet
34 . 46

B11-7-713

110 QC2- Inspect parts off machine FAI/FAIB 0.00

QC
Quality Control

B11-7-7

120 QC8- Inspect parts - second check 0.00

QC
Quality Control

8/10/11713

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



NC BRAKE

Brake NC

Brake NC

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/12

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

START TIME:

□FINISH TIME:

10:45 0.00

OVEN TEMPERATURE:

320°F

11-15

M 115/128

12X8 mdu/07/12

PTD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3535-23 PAR #: N/A Fault Category: Small P/B. water Jet NCR: Yes No DQA: 11/07/13 Date: 11.07.13
 11/07/13 Resolution: scrap Disposition: scrap QA: N/C Closed: 11/07/13 Date: 11/07/13

NCR: 71581		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/07/13	130	found 1 part with a default cut in it P.C. w/s moves with process still in the line process.	<u>BB</u> QA1012	Scrap & desho no Re-line Qty +1	BB 11/07/13	BB 11/07/13	<u>BB</u> QA1012	<u>S</u> 11/07/13

NOTE: Date & initial all entries

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Item ID: D3535-23

Accept



Setup

Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 7/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

QC3- Inspect Part Finish

0.00

12

BL 11-7-12

Quality Control

170



Packaging

Packaging

Identify as per dwg & Stock Location:

F-P Q1

0.00

Memo

180



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

Quality Control

0.00

12x Ø M-11/07/12

u-11-12 Ø

MF 11-07-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 06, 2011 1:24:51 PM

Page 1

Work Order ID: 71581



Parent Item: D3535-23



Parent Item Name: Wearshoe

Start Date: 7/6/2011

Required Date: 7/20/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased		No		100	sf	134.1630	1.3615	17.19789	 18. B11-7-7		

304/316 .040 Sheet

Location	Loc Qty	Loc Code
MAT020	134.163	
116623	0.2	
117550	9.363	
117933	124.6	117933

(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	71581
Description: Wearshoe		Part Number:	D3535-23
Inspection Dwg: D3535 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.885	✓		✓	
2.000	+/-0.010	2.00	✓		✓	
4.750	+/-0.010	4.756	✓		✓	
9.500	+/-0.010	9.506	✓		T B01	
14.250	+/-0.010	14.750	✓		T	
17.750	+/-0.010	17.756	✗		T	
23.140	+/-0.010	23.140	✓		T	
28.530	+/-0.010	28.536	✓		T	
33.920	+/-0.010	33.926	✓		T	
39.310	+/-0.010	39.310	✓		T	
44.700	+/-0.010	44.706	✗		T	
48.200	+/-0.010	48.200	✓		T	
52.850	+/-0.010	52.850	✓		T	
Ø0.188	+0.005/-0.001	.192	✓		✓ B02	
48.00	+/-0.030	48.00	✓		T	
39.00	+/-0.030	39.00	✓		T	
32.00	+/-0.030	32.00	✓		T	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
6.00	+/-0.030	6.00	✓		T	
0.300	+/-0.010	.304	✗		✓	
0.300	+/-0.010	.303	✓		✓	
0.038	+/-0.010	.034	✓		✓	

Measured by: B
Date: 11-7-11

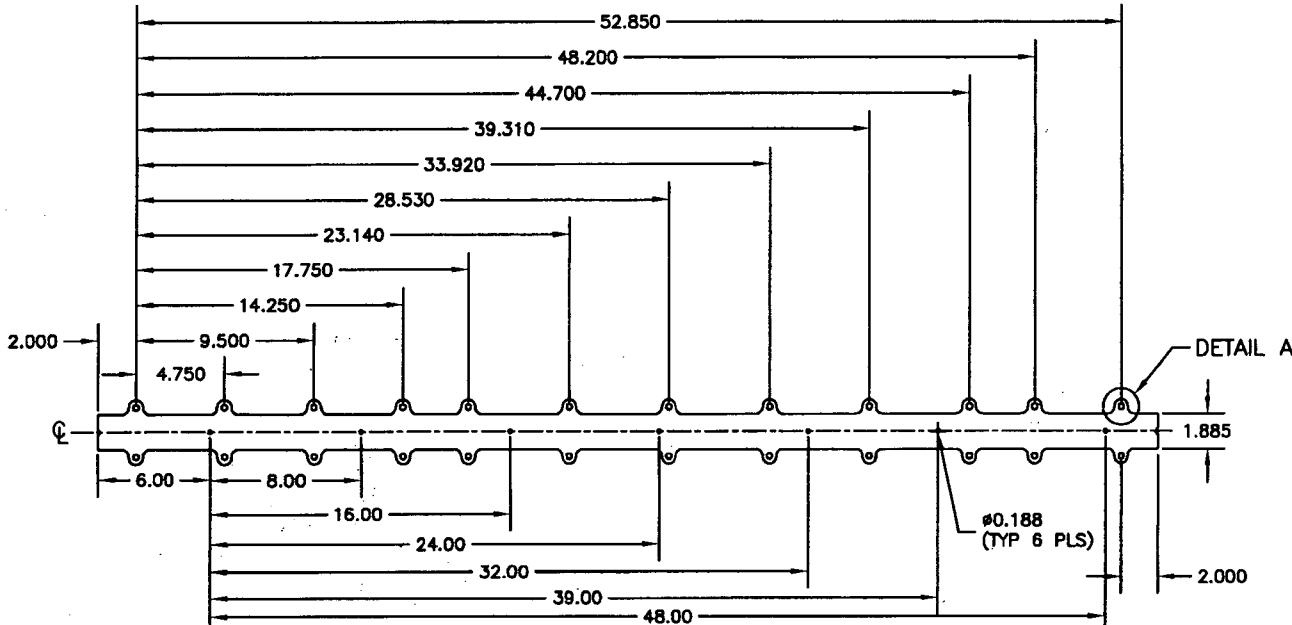
Audited by: S
Date: 11/17/11

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD, <u>SD</u>	<u>BS</u>

DART

DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED H	APPROVED H	DRAWING NO. D3535
DATE 07.04.17	TITLE WEARSHOE	REV. B SHEET 3 OF 7 SCALE 1:10



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71581

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524.
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

